

APPLICATOR STYLE CONVERSION CHART. Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

APPLICATOR DATA. Table with columns: CRIMP, SIZE, TYPE. Includes APPLICATOR INSTRUCTIONS 408-10389.

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED table.

WIRE SIZE, CRIMP HEIGHT, CRIMP HEIGHT REFERENCE SETTING. Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.



- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY.
ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62 & 180.
GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY.
SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING.
WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.00.

*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists various parts like APPLICATOR SHIM PACK, O-RING, PUSH ROD, BUSHING.

ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

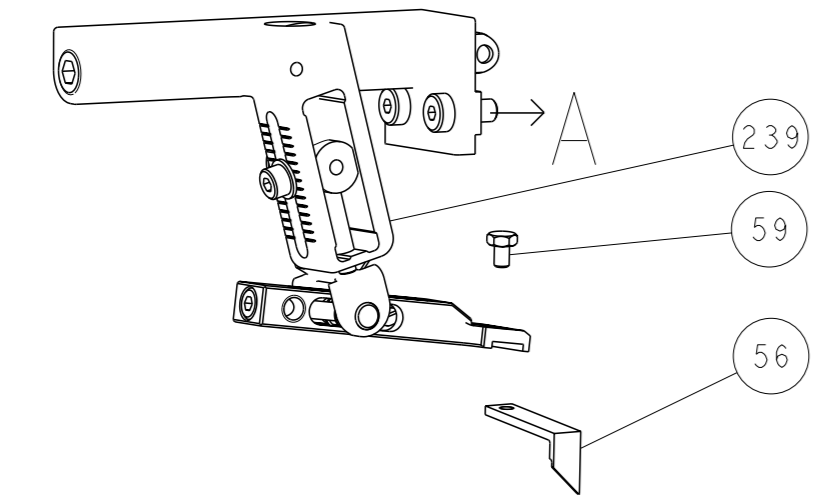
SET UP GAUGE, REVISIONS. Table with columns: P, LTR, DESCRIPTION, DATE, OWN, APVD.

Main parts list table. Columns: P, LTR, DESCRIPTION, DATE, OWN, APVD. Lists numerous components like FEED CAM, DETENT PIN, SPRING, RAM, WASHER, SCR, etc.

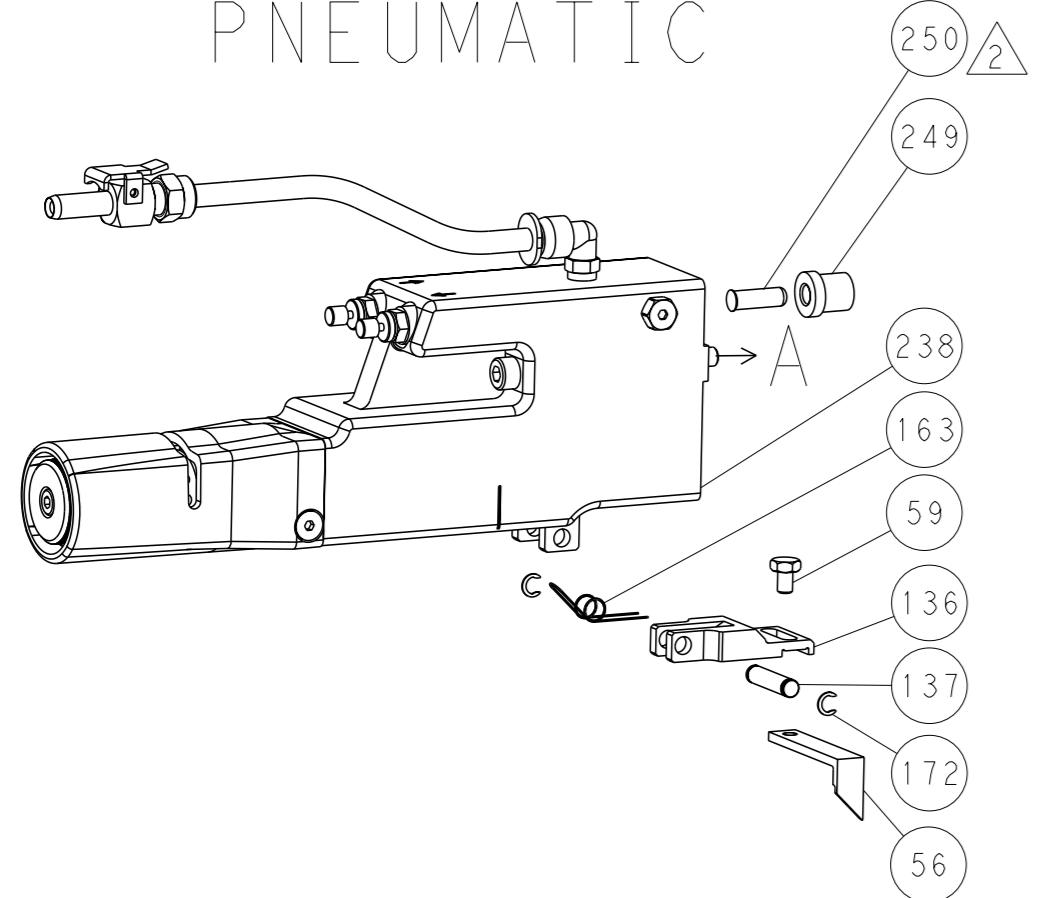
TE Connectivity logo and product information. Includes dimensions, tolerances, material, weight, and scale information.

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

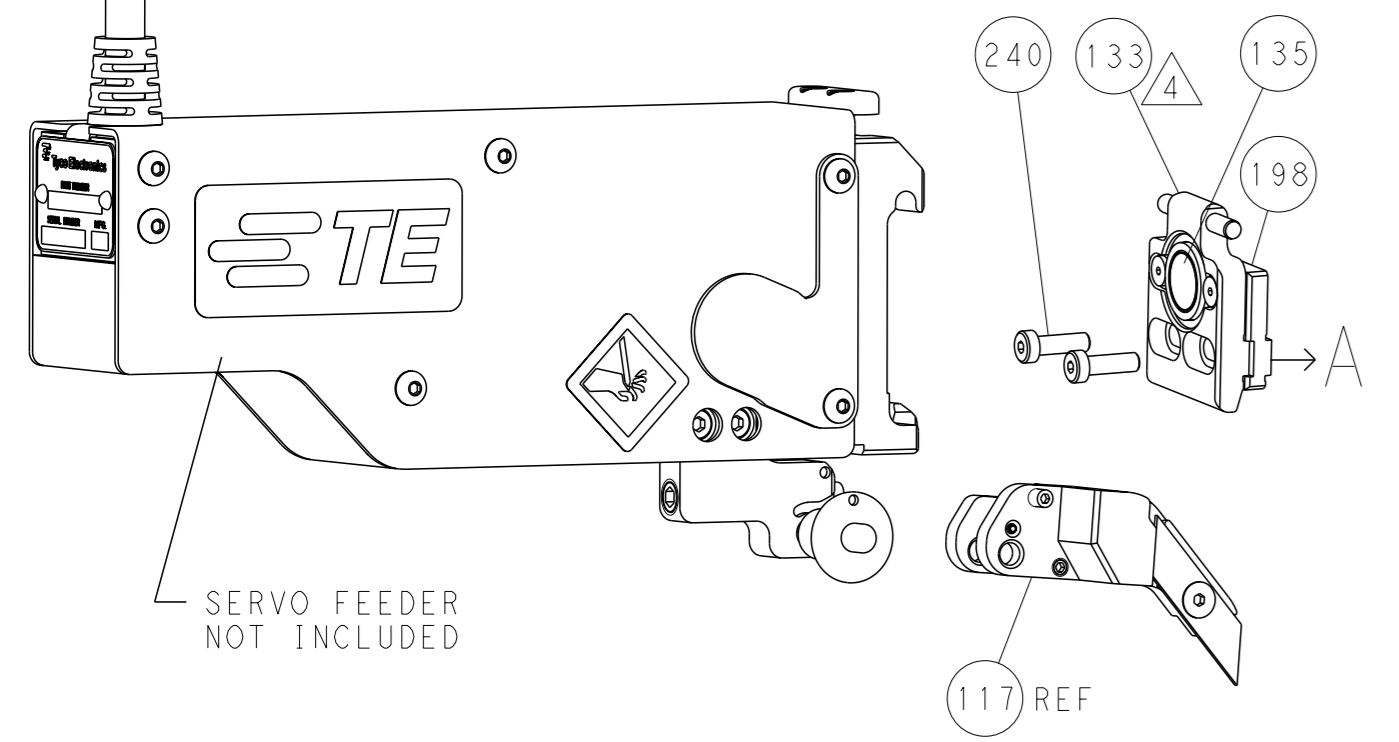
FEED TYPE MECHANICAL



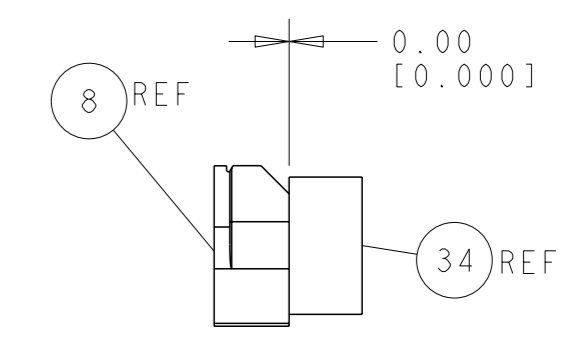
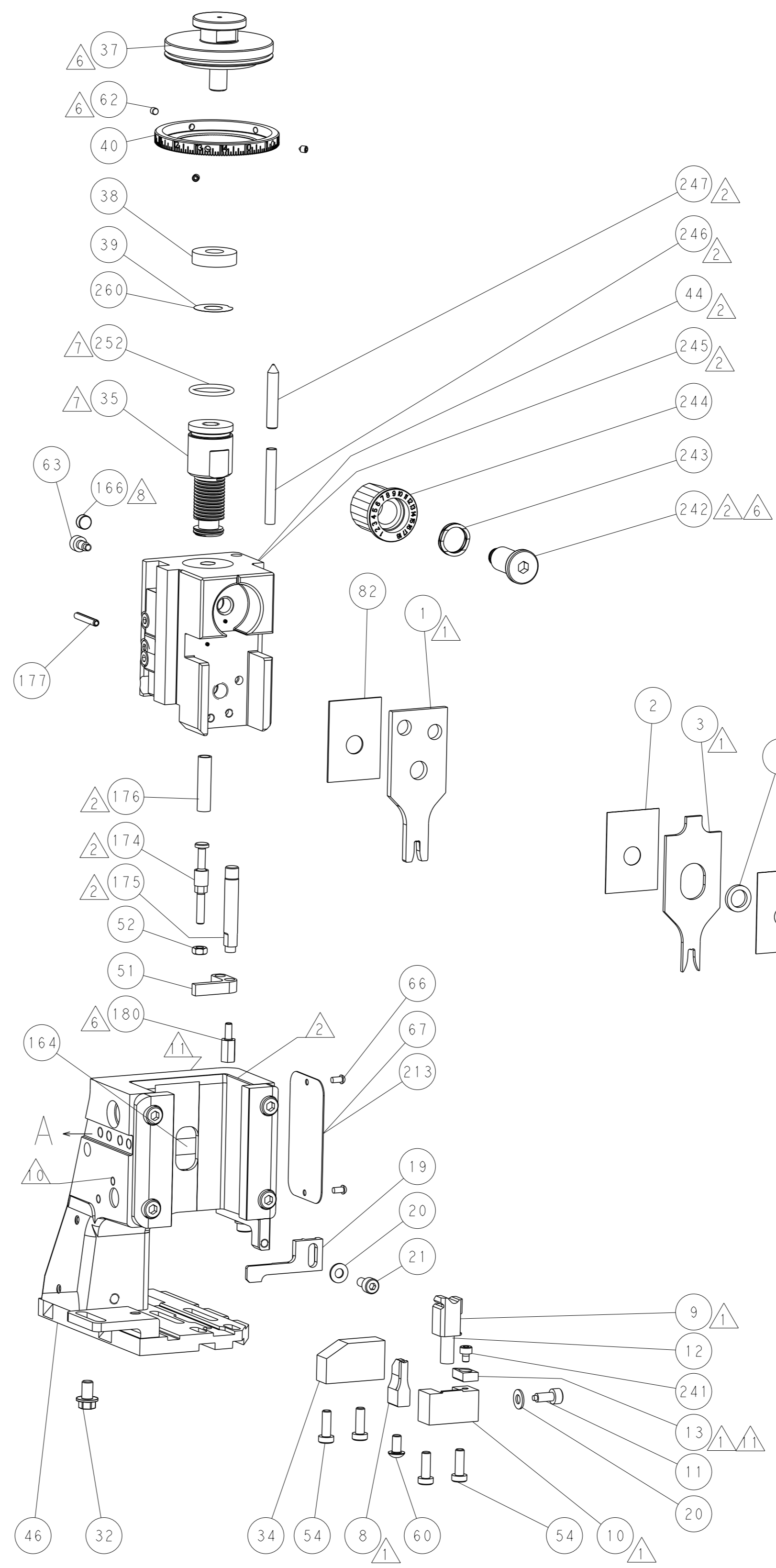
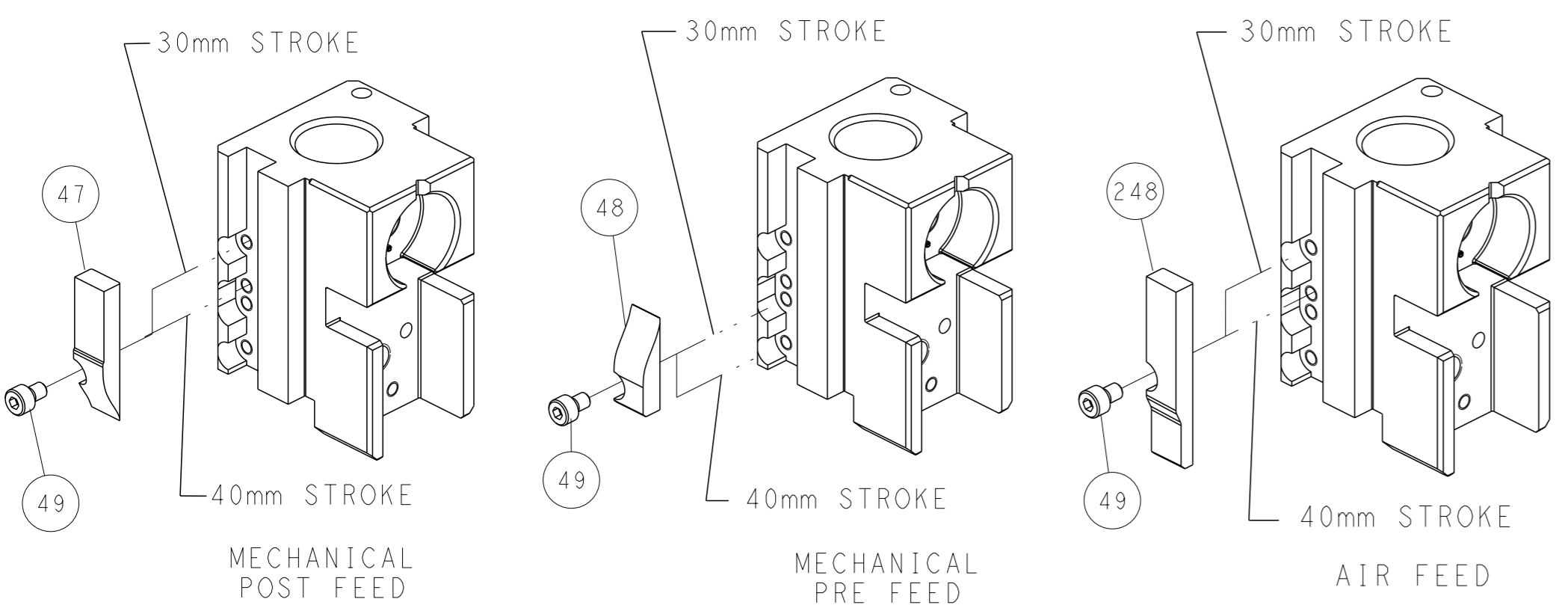
PNEUMATIC



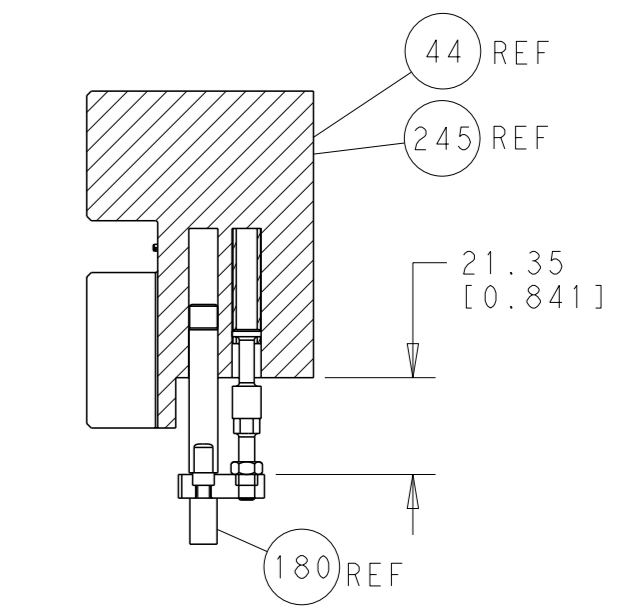
SERVO LATCH PLATE



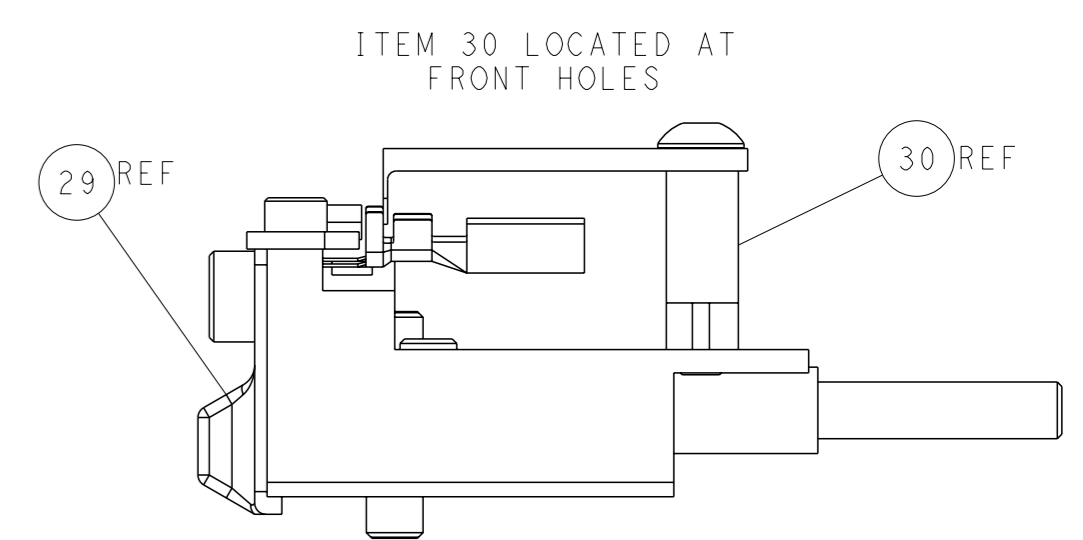
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		DWG Y. YIN 04FEB2015 CHK G. BAILEY 04FEB2015 APVD U. GUO 04FEB2015		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2266608	
MATERIAL		WEIGHT		SCALE 1:2		SHEET 2 of 4 REV A	

APPLICATOR STYLE CONVERSION CHART
Table with columns: CONVERT TO, PART NUMBERS REQUIRED (PNEUMATIC FEED, SERVO LATCH PLATE, SMART APPLICATOR, MECHANICAL FEED, etc.)

APPLICATOR DATA
CRIMP SIZE TYPE
WIRE 2.54 mm [.100] F
INSUL 3.50 mm [.138] F
APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION
TERMINAL NAME: TERMINAL
WIRE STRIP LENGTH 4.20-4.80 mm [1.65-.189 IN]
INSULATION DIAMETER RANGE Ø2.00-3.00 mm [0.079-.118 IN]
TERMINAL APPLICATION PG. 1 of 5
TERMINALS APPLIED

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING
2.50mm2 1.80 +/- 0.05 [0.071 +/- .002] 4.5
1.50mm2 1.60 +/- 0.05 [0.063 +/- .002] 6.3

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER: MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266608-4 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266608-4 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266608-5
- ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

Table with columns: ITEM NO, PART NO, DESCRIPTION
- 1 1 1 1 2119782-1 FINE ADJUST HEAD ASM, PACIFIC STYLE 251
- - - 1 - 2119640-1 PUSH ROD, AIR FEED 250

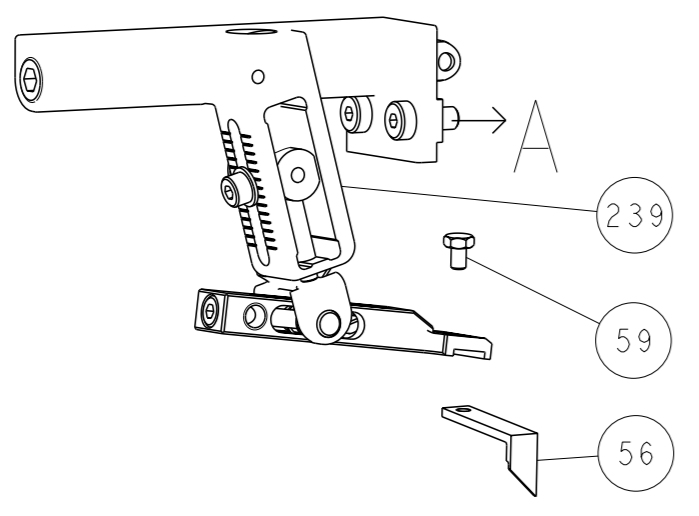
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

Large table with columns: QTY, DESCRIPTION, DATE, QTN, APVD
Includes various parts like BUSHING, SPRING, CAM, WASHER, RETAINER, SCR, TAG, SPACER, STANDOFF, PIN, GUIDE PIN, RING, MAGNET, SPRING, O-RING, FEED CAM, DETENT PIN, SCR, SHCS, FEED CAM, APPLICATOR BASIC ASSEMBLY, RAM, BOLT, PIN, HOLDER, MEMORY CHIP, SERVO FEED LATCH ASM, FEED FINGER ASSEMBLY, SPACER, CRIMPER, DOCUMENTATION PACKAGE, TAG, IDENTIFICATION, SCREW, DRIVE, RH, ROHS, LIMITER, ADJUSTMENT BOLT, SCR, SET, SOC, CONE POINT, M3 X 4.0, FEED PAWL, NUT, HEX, REG, ROHS, M3.5, HOLDDOWN, TERMINAL, SCR, SKT HD CAP M4 X 6.0, FEED CAM, PRE FEED, SCR, BHSC, ROHS (M8 X 25), DISC, NUMBERED FA WIRE ADJUSTMENT, APPLICATOR SHIM PACK, RAM WASHER, PRECISION, SUPPORT, TERMINAL, SCR, BHSC, ROHS (M4 X 20), HEX HEAD, FLANGED, M5 X 8mm LONG, SPACER, STRIP GUIDE, ASSEMBLY, STRIP GUIDE, SPACER, CRIMPER, STRIP GUIDE, SCR, SKT HD CAP, ROHS, M4 X 8.0, WASHER, FLAT, REG M4, STRIPPER, SIDE FEED, INSERT, SHEAR, SPRING, COMPRESSION, STOP, SHEAR, SHEAR HOLDER, FRONT, FLOATING SHEAR, FRONT, ANVIL, COMBINATION, DEPRESSOR, SHEAR, BLOCK, CRIMPER SPACER, CRIMPER, INSULATION F PREMIUM, SPACER, CRIMPER, CRIMPER, WIRE PREMIUM

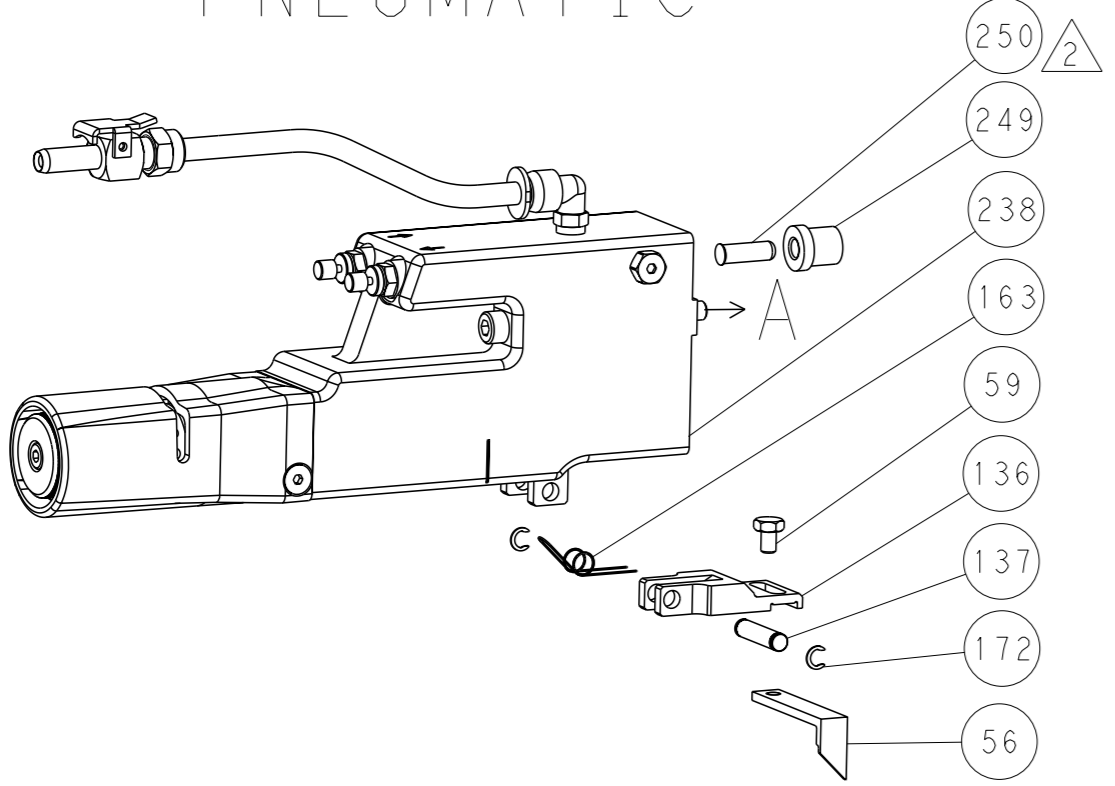
TECHNICAL SPECIFICATIONS (DIMENSIONS, TOLERANCES, MATERIAL) and CUSTOMER INFORMATION (DRAWING NO, SCALE, SHEET 3 OF 4, REV A)

LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

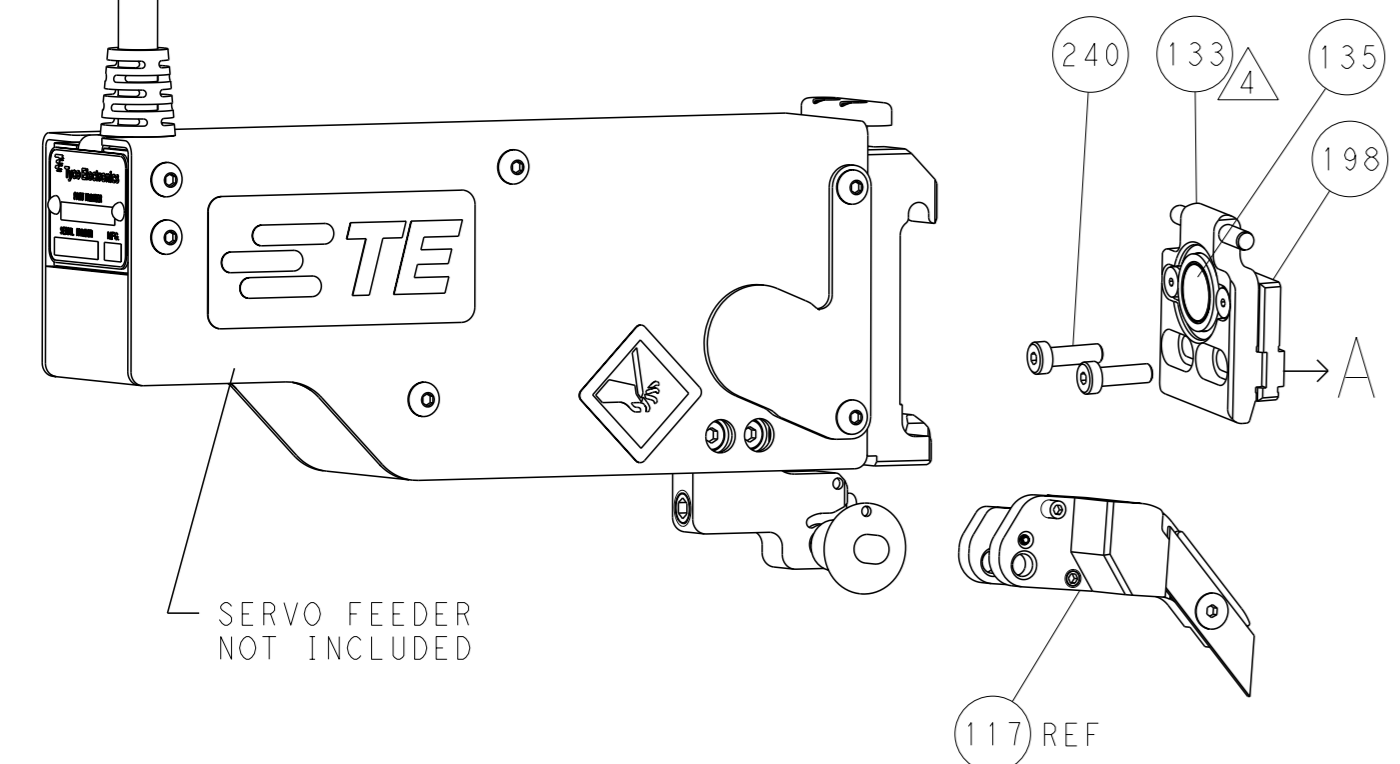
FEED TYPE MECHANICAL



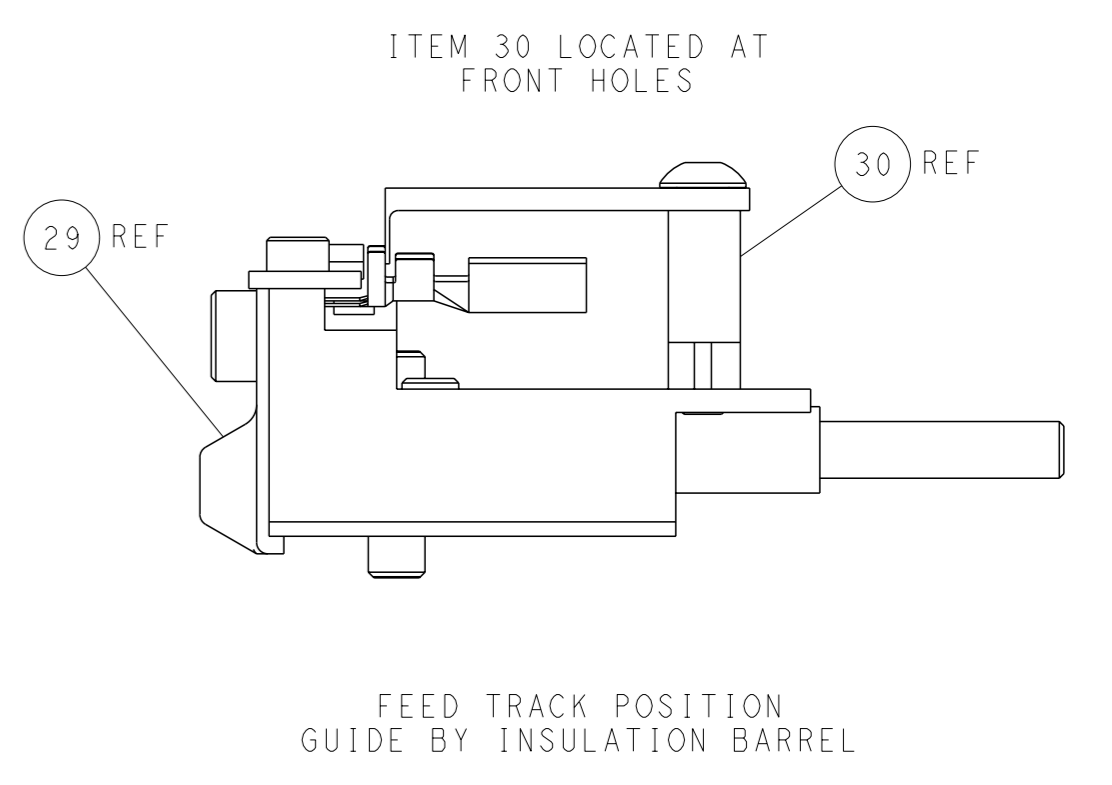
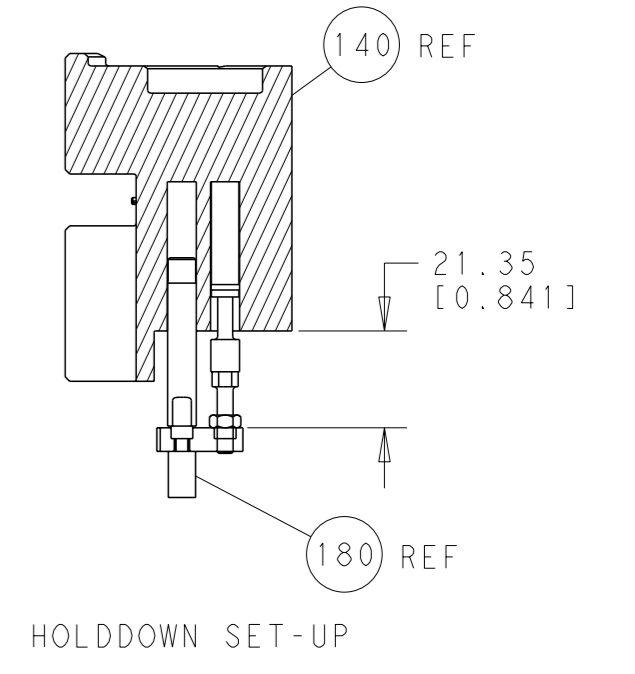
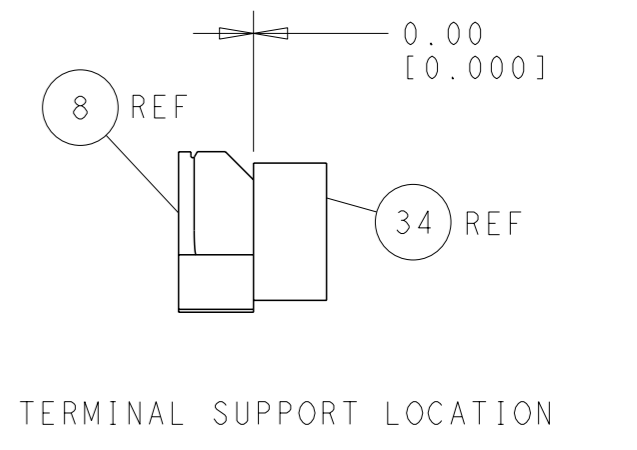
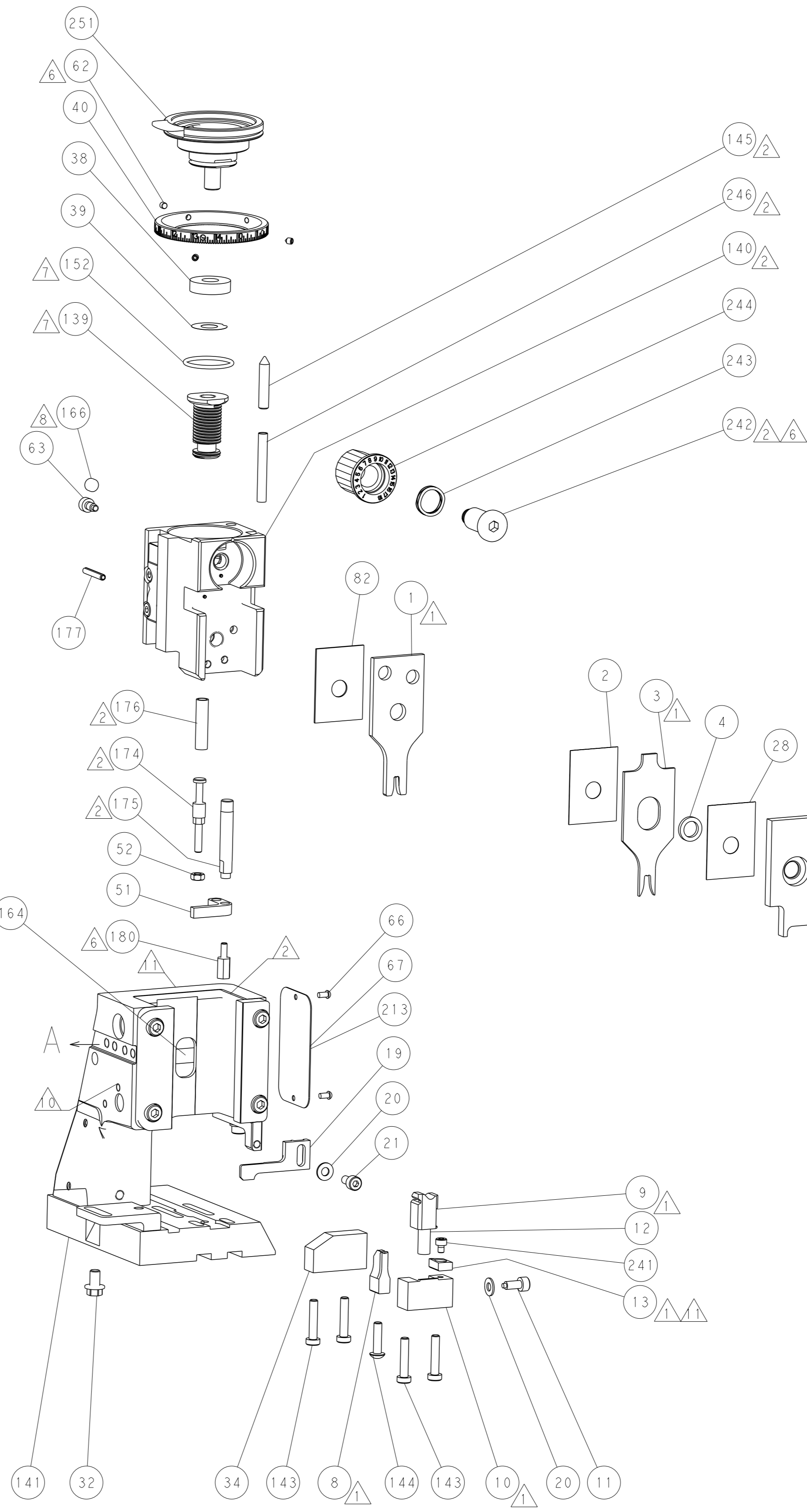
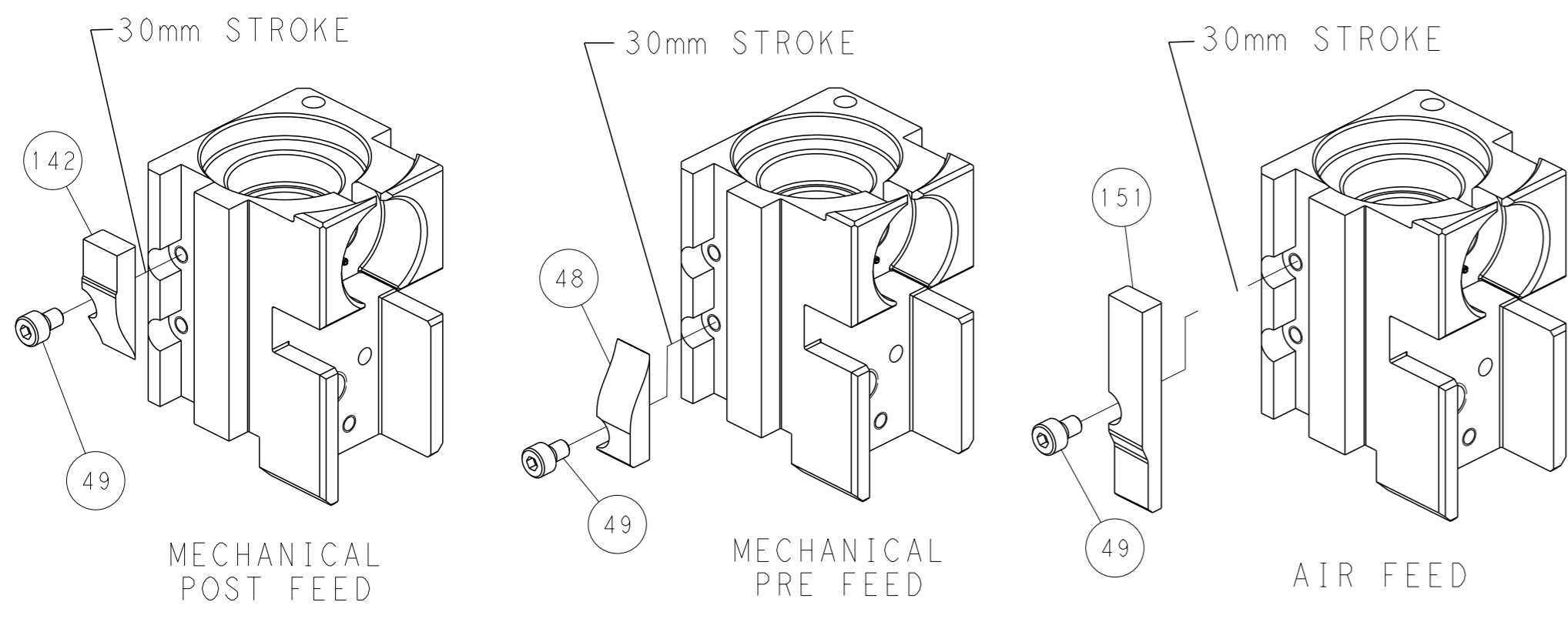
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER SHALL CONTACT THE DESIGNING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN Y. YIN 04FEB2015 CHK G. BAILEY 04FEB2015 APVD U. GUO 04FEB2015	NAME STE TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH ±.	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	SIZE CAGE CODE DRAWING NO A1 00779 C=2266608 RESTRICTED TO SHEET 4 OF 4 REV A
MATERIAL:		Customer Accessible Production Drawing	